

Work Order ID 70649

Friday, June 10, 2011 3:57:28 PM



Page 1

Item ID: D3391-021

Accepted



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 6/10/2011 **Start Qty:** 1.00

Cust Item ID:

Required Date: 6/30/2011 **Req'd Qty:** 1.00

Customer:

Reference:

Approvals: Process Plan: MR

Date: -06-10

Tooling:

Date

Run Start



- QC:

Date:

SPC (Y/N):

Date:

Stop



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3391-021

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

HAAS CNC VERTICAL MACHINING #1

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

B.A 11/06/20

1

0

140



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/06/20

1

0

Quality Control

150



Mill Conv

CONVENTIONAL MILLING MACHINE

0.00

OK 11/06/22

1 0

Conventional Milling Machine

Memo

0.00

Drill X1 Aft cap as per Dwg D3391 .1875" dia

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D3391-021

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation #
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

on 2/10/22

1 0

170



QC

Quality Control

QC8- Inspect parts - second check

0.00

SL 11/06/22

Memo

0.00

Memo

0.00

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo
1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes .328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

(X1)

BB 11/06/22

190



QC5- Inspect part completeness to step on W/O

0.00

0.00
5/10/13

QC

Quality Control

Memo

0.00

(QD)

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

SAD 11-06-23



Hand Finishing

210



QC3-Inspect Part Finish

0.00

1 0 RE 11/06/23

QC

Quality Control

220



Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391
 A/R Magnabond 6398 batch: *u116945*
 exp. date: *12/01/15*
 cure time 12hrs. as per QSI015
 2- grind crossbolt flush
 3-back drill crossbolt if necessary

u/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

S M 6/12/11

(40)



QC

Quality Control

235

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

1 BL 11-6-24.

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

11:20 00
START TIME: 320 °F
OVEN TEMPERATURE:
FINISH TIME: 11:50

X S m-f 11/06/27

Powder Coating

M 117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**

250



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

1 4 M u06128

255



Skidtubes

Skidtubes

0.00

1 4 M u06128

Skidtubes

Memo

0.00

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG ****

257



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S u06129

x 1 1 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 70649

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Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

260



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: W10Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

D412-742-043 / B70643

1 0 H1 Loc125

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/30 48

UMC

11-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, June 10, 2011 3:57:24 PM

Page 1
3

Work Order ID: 70649



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 6/10/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A 05.09.13 New issue KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047 		Manufactured	No			100	Each	21.0000	1	1			

Skidtube Material

Location	Loc Qty	Loc Code
LG	21	
	21	

D3670-4-200



Manufactured

No

220

Each

31.0000



SPACER

BB 11/06/13

26
11/06/23

D3401-041



Manufactured

No

255

Each

6.0000



Tow Cap Assembly

Location	Loc Qty	Loc Code
FP007	6	

61505

6

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, June 10, 2011 3:57:24 PM

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Work Order ID: 70649



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 6/10/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13



Manufactured No

255

Each

27.0000

1

1



M1 ulo6128

Wearshoe

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP016	18	
	69280	18	
	FP017	9	
	66805	9	

D3566-13



Manufactured No

255

Each

39.0000

1

1



M1 ulo6128

Gasket

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	26	
	69281	26	
	FP014	13	
	68341	13	

AN960C10L

NAS1149C0332 R



Purchased No

255

Each

0.0000

10

10



M117887

(x10) M1 ulo6128

washer

AN3C4A



Purchased No

255

Each

1,929.000

10

10



M1 ulo6128

BOLT

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST350	1929	
	117094	427	
	117313	2	
	117688	800	
	117795	500	
	117872	200	

M118112

x10

W/O:		WORK ORDER CHANGES					
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Friday, June 10, 2011 3:57:24 PM

Page 3

Work Order ID: 70649



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 6/10/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured

No

255

Each

1,176.000

4

4



JU 1106128

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST074	1150	
-------	------	--

64177

650

X4

66821

500

ST077

26

52505

26

AELS-1032-130

Purchased

No

255

Each 0.0000

2

2

M 117717



(x2) JU 1106128

INSERT

AELS-1032-225

Purchased

No

255

Each 0.0000

10

10

X 117717



(x10) JU 1106128

INSERT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70649
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

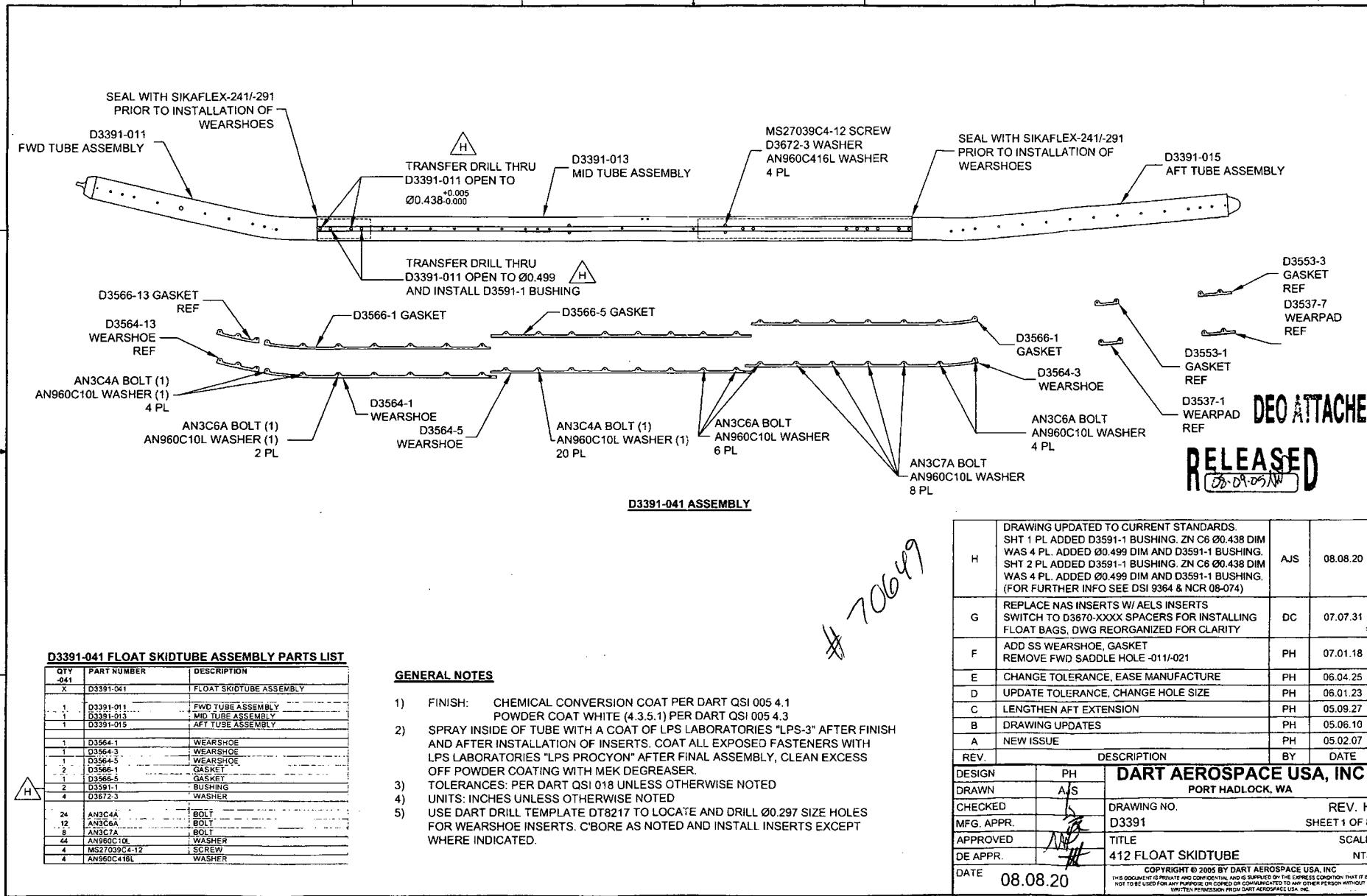
FIRST ARTICLE INSPECTION CHECKLIST

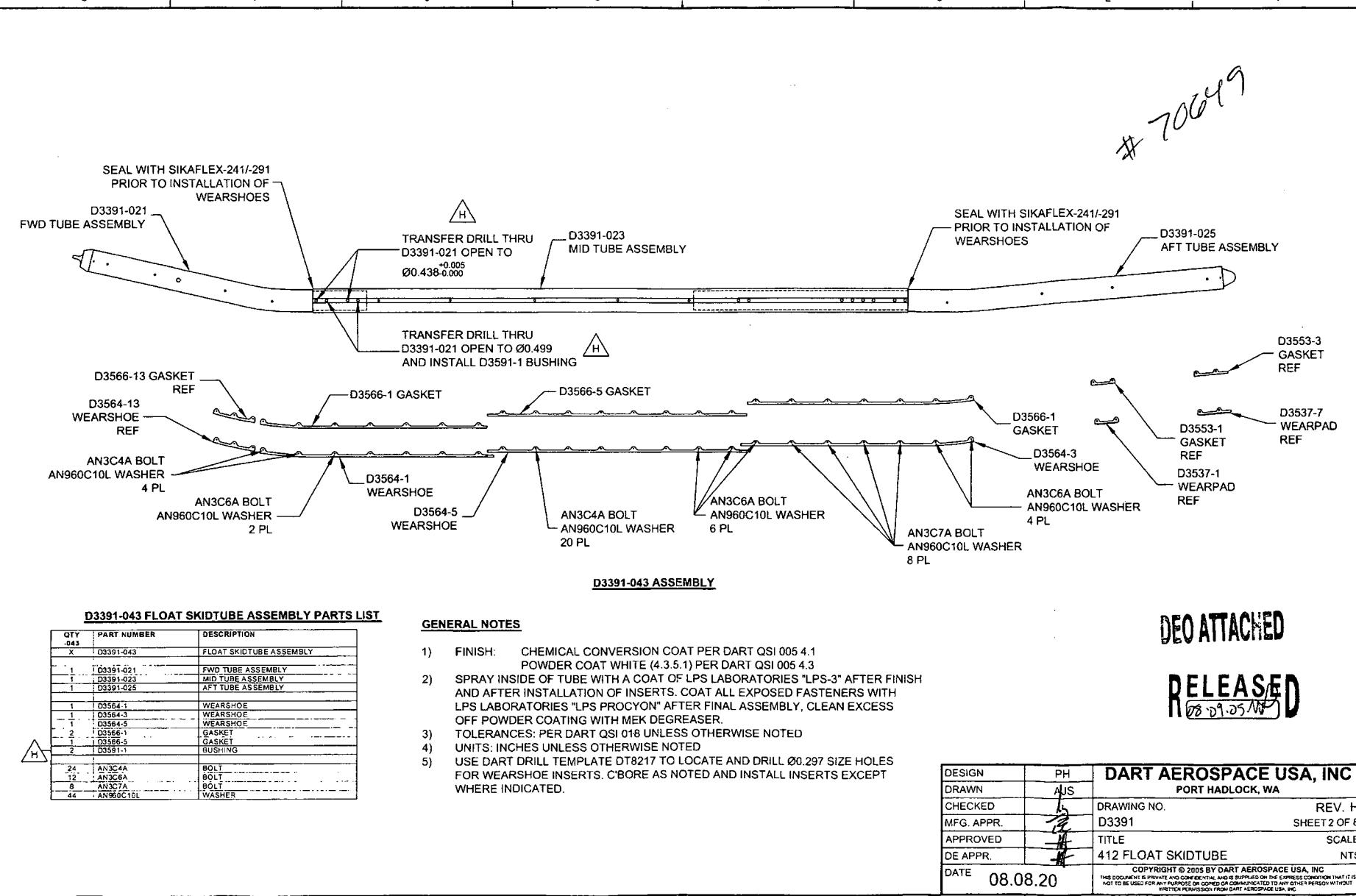
X First Article Prototype

Measured by:	A. Tomk	Audited by:	JL	Prototype Approval:	N/A
Date:	11/06/20	Date:	11/06/20	Date:	N/A

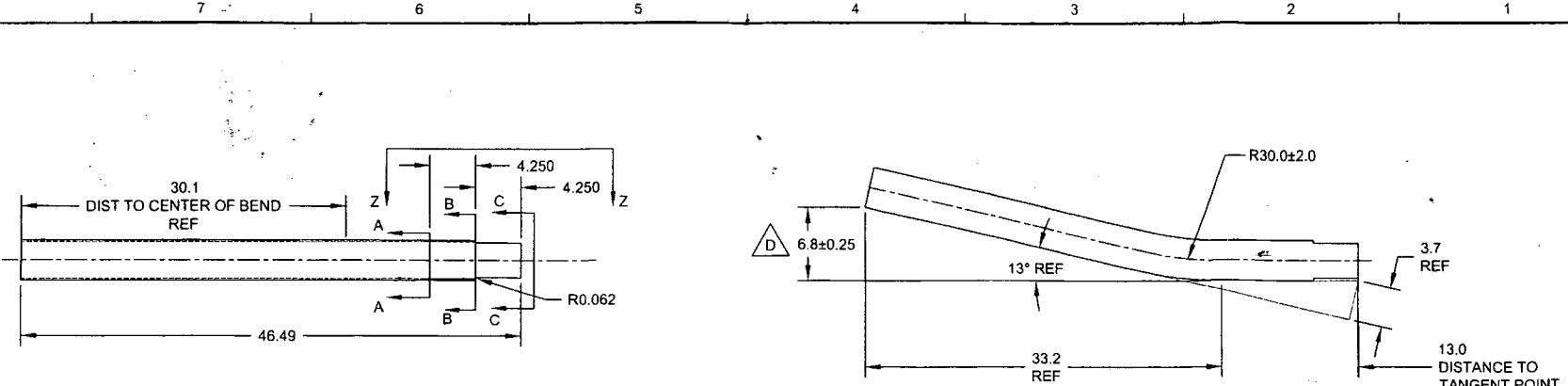
Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	
E	09.12.14	Dwg Rev updated	KJ	MM



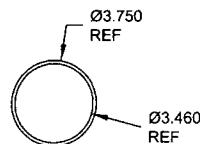




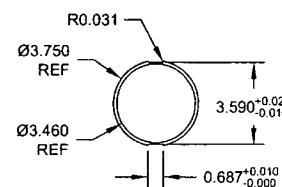




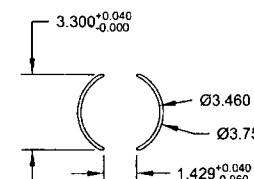
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



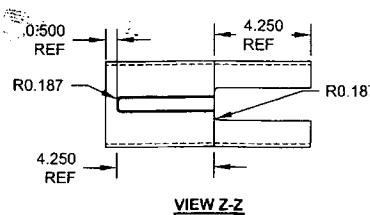
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



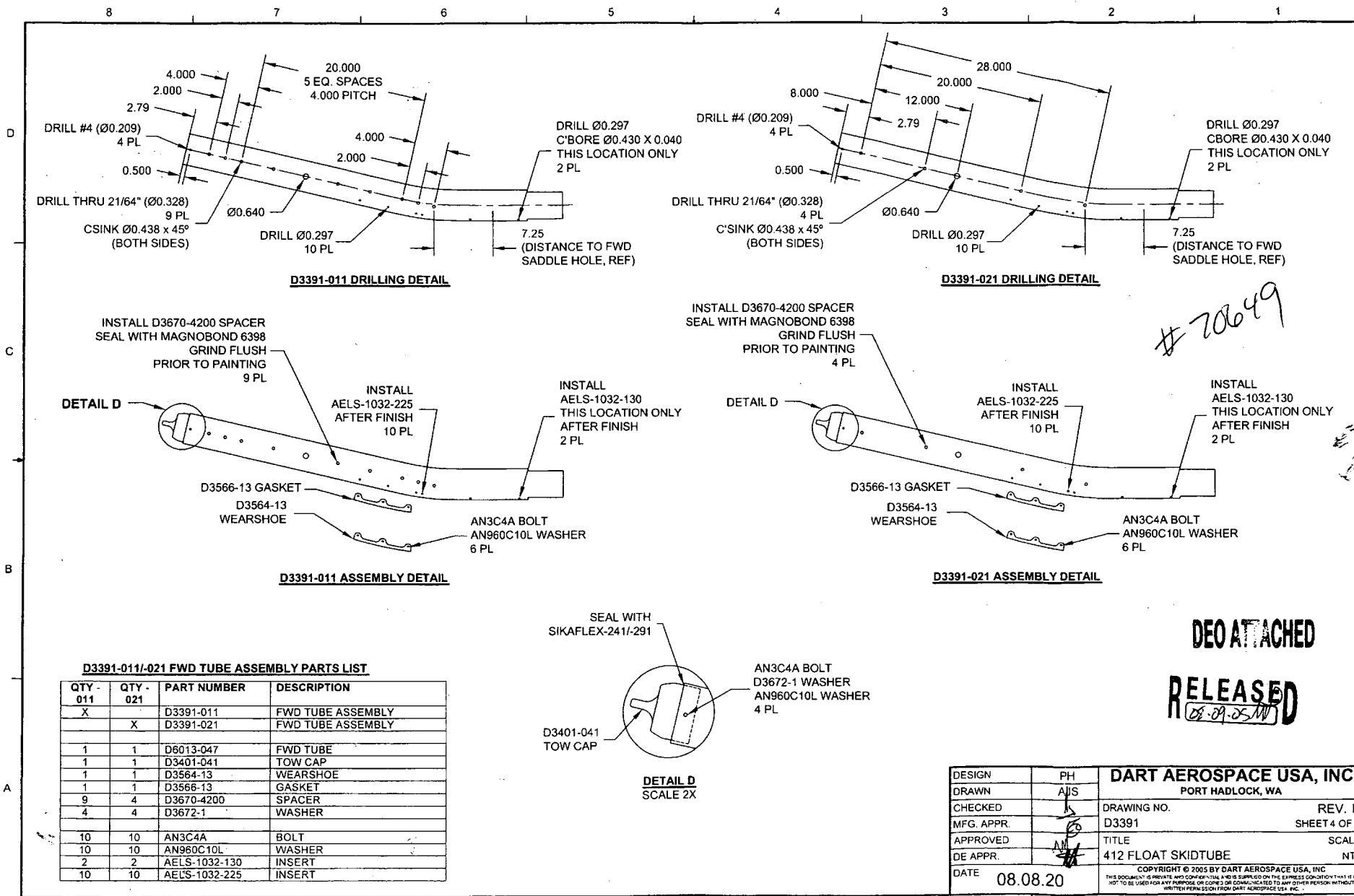
VIEW Z-Z
SCALE 2X

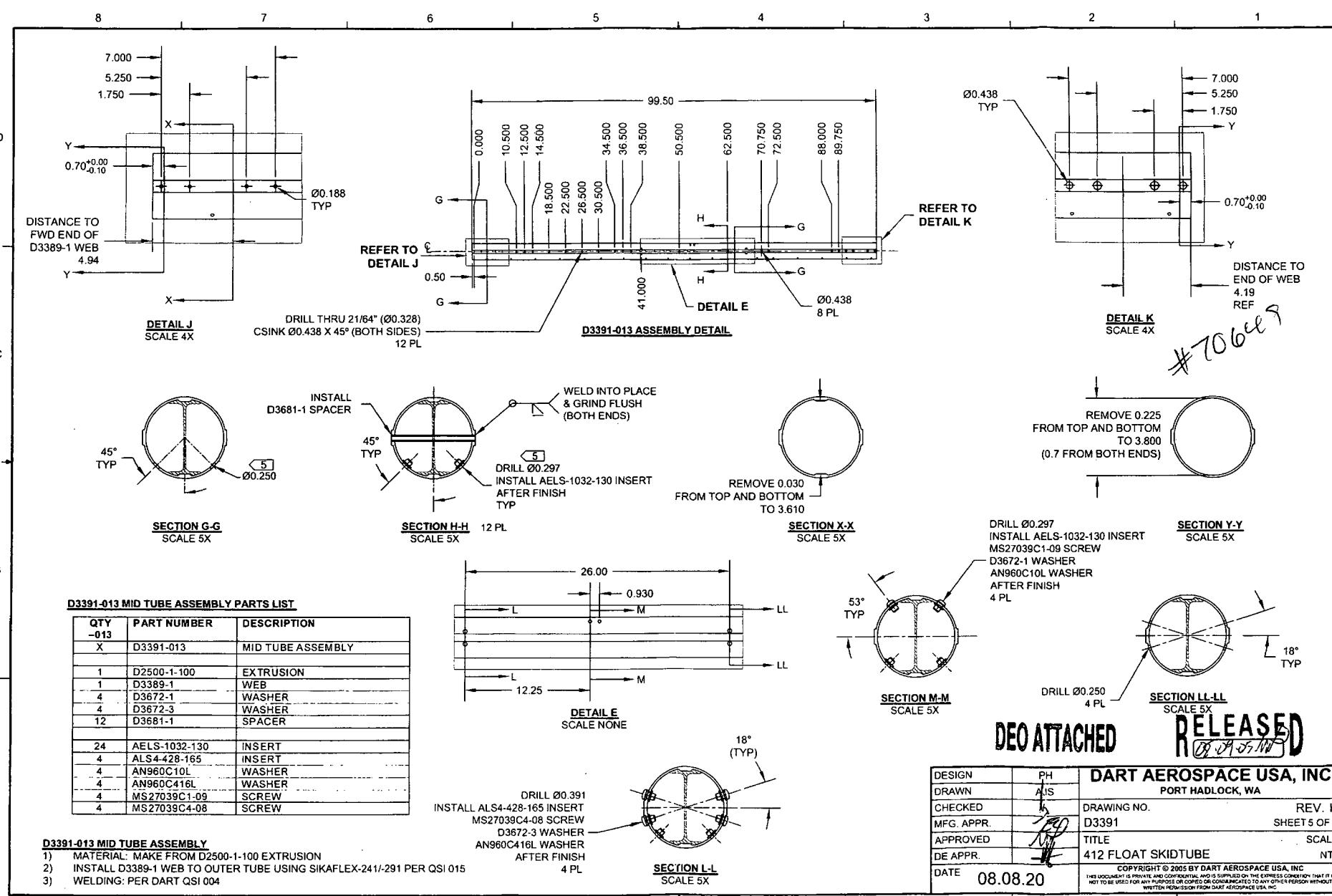
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3391	REV. H
APPROVED		SHEET 3 OF 8	
DE APPR.		TITLE	SCALE
		412 FLOAT SKIDTUBE	NTS
		DATE 08.08.20	

DE ATTACHED
RELEASED
08.08.20

8 7 6 5 4 3 2 1

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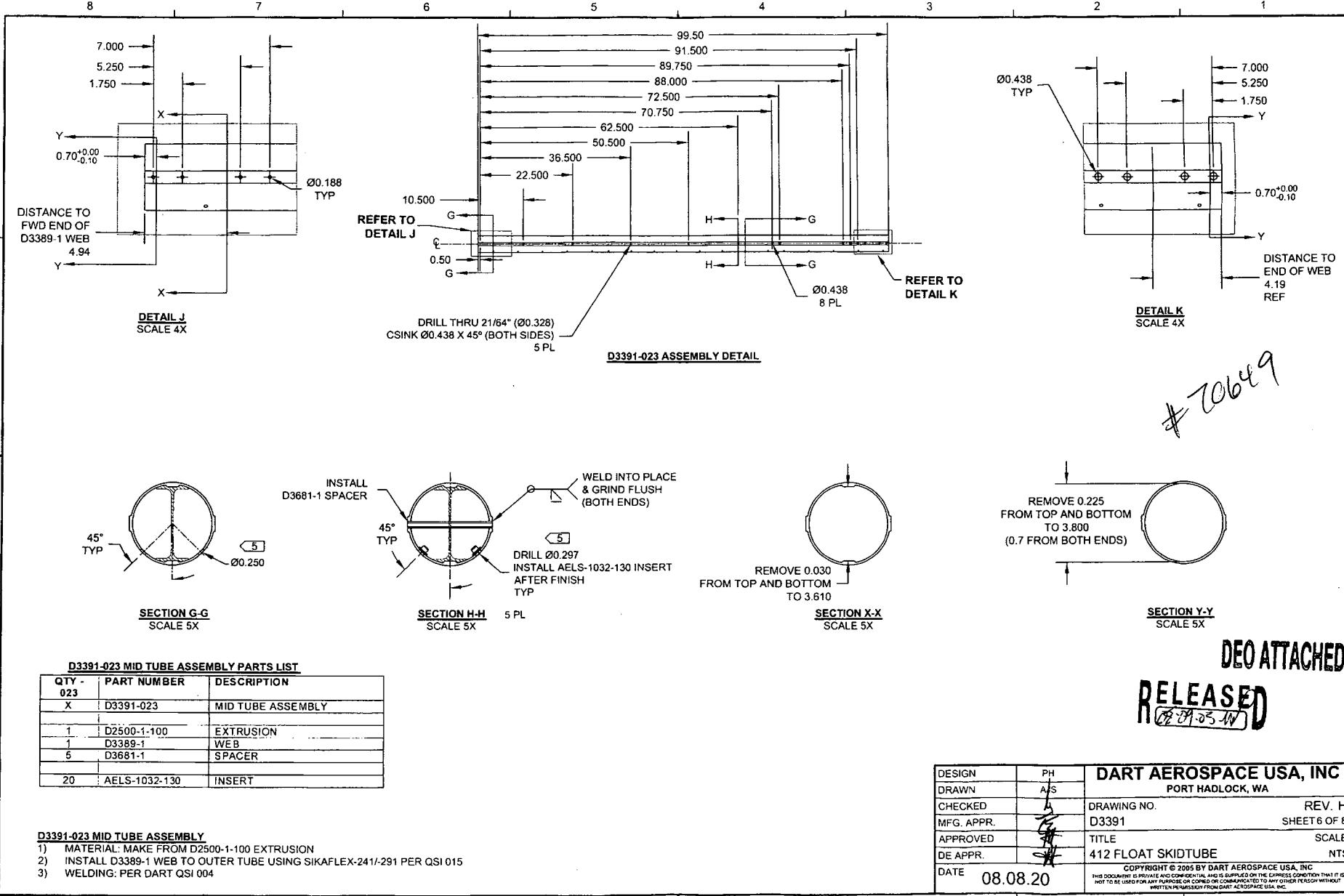


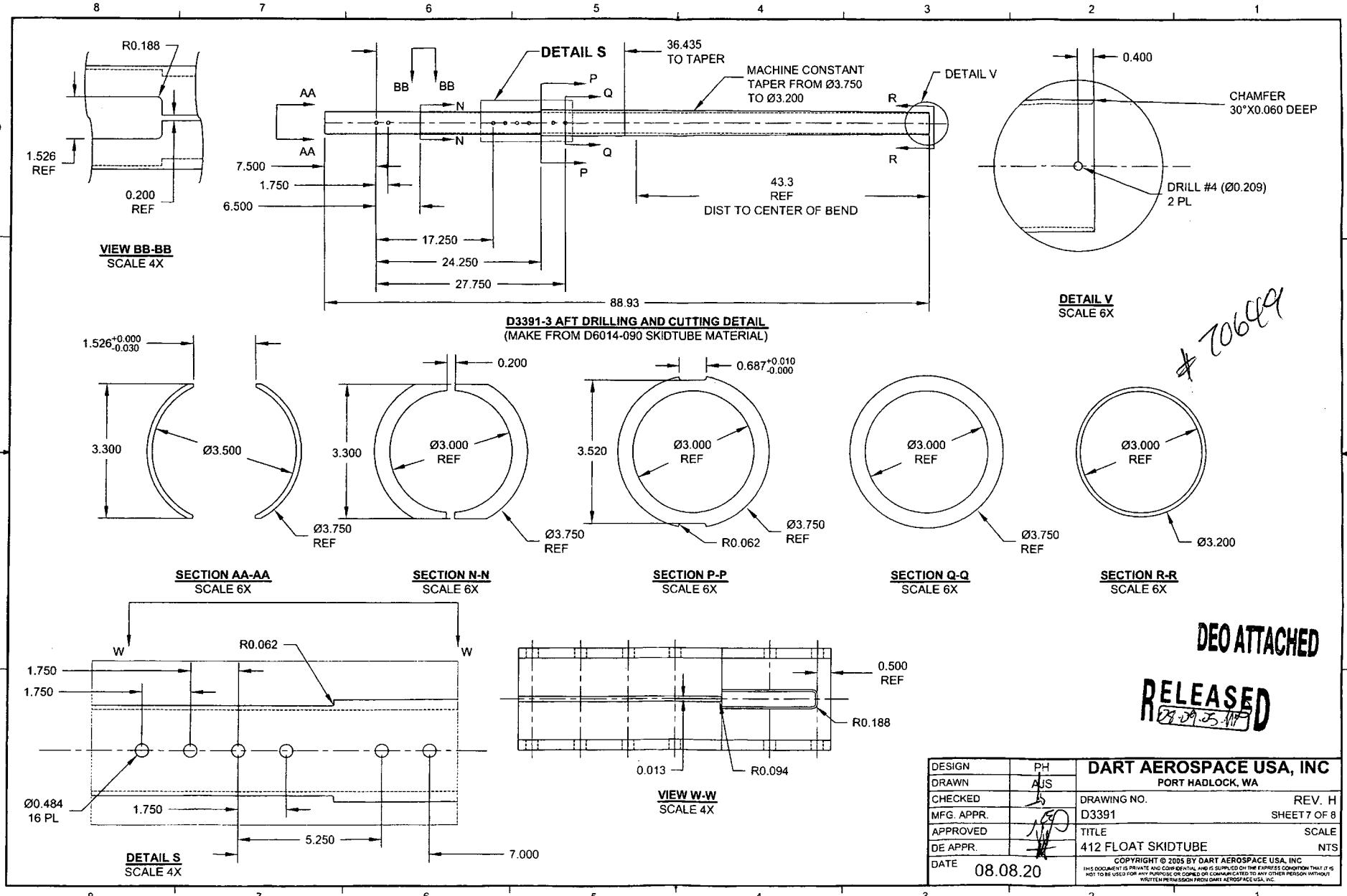


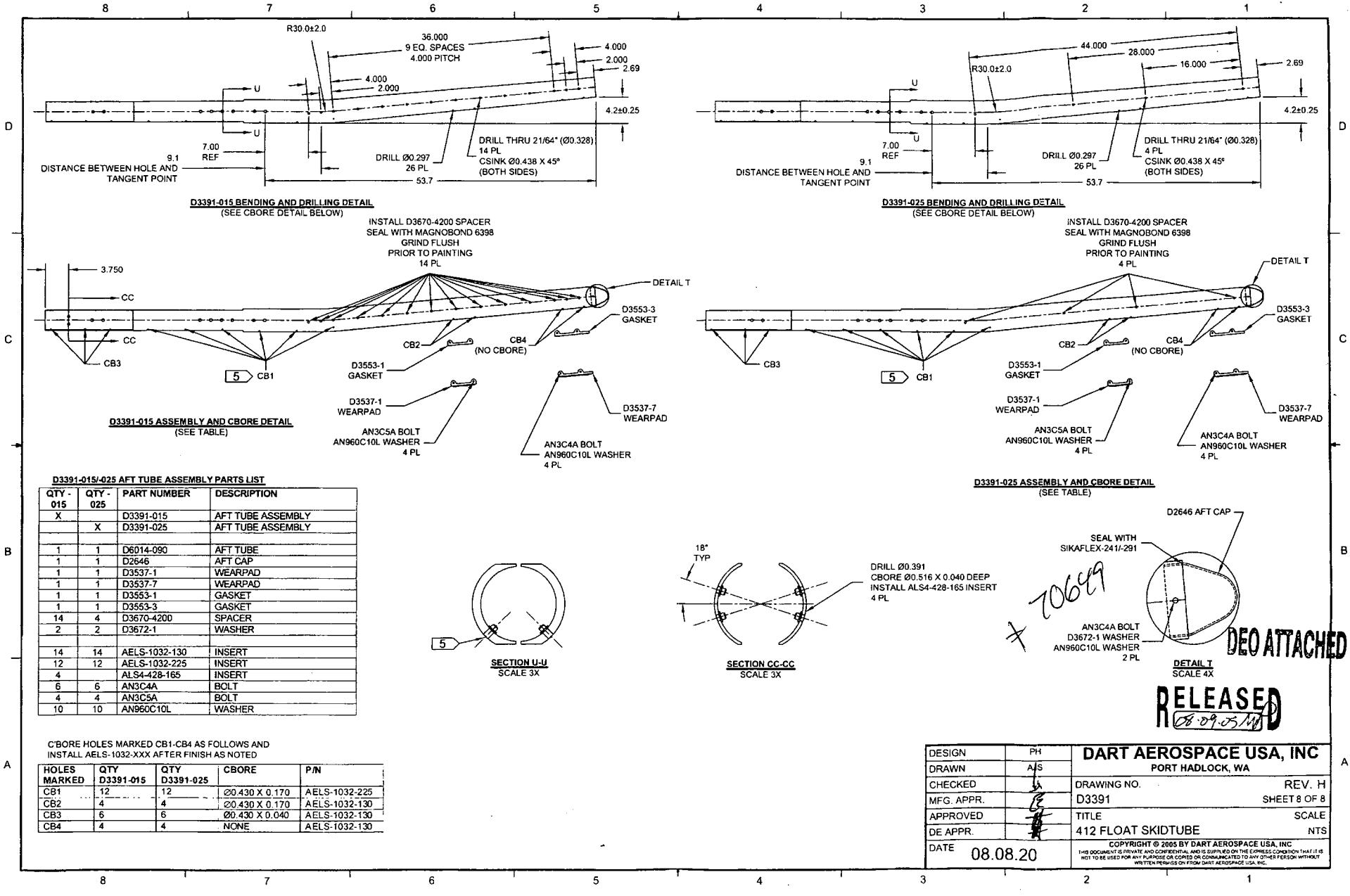
DEO ATTACHED

SCALE SX
RELEASED
09-09-00

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AIS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	







DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>J</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>HP</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

#706cl9

